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U/R

SMY
12/10/18

D117-1028-013

Job Sheet 197859



Part No: D117-1028-013

Job Qty: 1 pcs

Part Name: EC145T2 Bearpaws with Wearplates

Part Weight: 0 lbs

Job Created: 7/18/19

Due Date: 8/20/19

Type: SOLD

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

POSITIVE RECALL

EFFECTIVE 12/10/18 AUTH SMY

RELEASED 68 DATE OCT 11 2019

Note: URF 19-605 IIN-D117-1028 prelim-REV.C IPP REV:A 18.11.20 NEW ISSUE DD VERF:JFS IPP REV:B
19.03.20 AS PER PRELIM REVC DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Packaging 1 - Pick Kit	1 pcs		8/20/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S223462

Part: D117-1028-013

Job No: 197859

Serial No/Batch: S223462

Revision: C

Inspector:

Exp Date:

Instructions: FAA STC SR02508SE 19/02/15v15sLoA C-17

Due 8-27-2019

Oscar

					Packaging 1 - 31		
					Packaging 1 - 32		
					Packaging 1 - 33		
					Packaging 1 - 34		
					Packaging 1 - 35		
					Packaging 1 - 36		
110 QC 4	1 pcs	8/20/19	0.00 0.00		QC 4 - 28		
					QC 4 - 58		
					QC 4 - 69		
					QC 4 - 9		
					QC 4 - 46		
					QC 4 - 68		
					QC 4 - 72		
					QC 4 - 74		
					QC 4 - 75		
120 Packaging 3-1 - Stock - B4B	1 pcs	8/20/19	0.00 0.00		Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
130 DC - 1 - B4B	1 pcs	8/20/19	0.00 0.00		DC - 1 - B4B		
					DC - 2 - B4B		
140 QC 21 - FG	1 pcs	8/20/19	0.00 0.00		QC 21 - FG - 21		
					QC 21 - FG - 70		
					QC 21 - SA - 53		

Part Op 100 - Pick kit

Descriptions: 110 - QC4- 100% Inspect kits for completeness

120 - Package and Identify as per PPP D117-1028-013

130 - Photocopy bluefile and type labels per PPP D117-1028-013 CHG 001

140 - QC21- Final Inspection - Work Order Release

DAS

78

9-89

DAS

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OCT 17 2019

FG Deck

011611

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C5A	Bolt	16 Ea (16 ea) ✓	100-Packaging 1 - Pick Kit	S207679 ✓
D2529	Washer	24 pcs (24 ea) ✓	100-Packaging 1 - Pick Kit	S161059 ✓
D4012-3 ✓	Cushion <i>BEVE</i> ✓	4 pcs (4 ea) ✓	100-Packaging 1 - Pick Kit	S046592 ✓
D5718-3	Bearpaw Clamp <i>A</i> ✓	4 pcs (4 ea) ✓	100-Packaging 1 - Pick Kit	ok S218867 S218789 ✓
D5719-1	Radius Block <i>A</i> ✓	8 pcs (8 ea) ✓	100-Packaging 1 - Pick Kit	ok S218867 S218908 ✓
D5732-1	Bearpaw <i>A</i>	2 pcs (2 ea) ✓	100-Packaging 1 - Pick Kit	S218835 ✓
D5733-041	Bearpaw Wearplate <i>A</i> ✓	2 pcs (2 ea) ✓	100-Packaging 1 - Pick Kit	S221559 ✓
MS21043-4	Nut <i>24</i>	16 Ea (16 ea) ✓	100-Packaging 1 - Pick Kit	S198136 ✓ S 203359 ✓
MS21083C4	Nut	8 Ea (8 ea) ✓	100-Packaging 1 - Pick Kit	S147760 ✓
NAS1149D0463J	Washer	8 Ea (8 ea) ✓	100-Packaging 1 - Pick Kit	S145362 ✓
NAS1802-4-26 <i>24</i>	Bolt <i>GA200</i>	8 Ea (8 ea) ✓	100-Packaging 1 - Pick Kit	ok S201512 ✓ S223458
<i>D5718-1</i>	<i>CLAMP</i>	<i>4ea</i>	<i>"</i>	<i>S218771</i> ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN4C5A	16	53	0
	D2529	24	1,044	0
	D4012-3	4	35	0
	D5718-3	4	4	0
	D5719-1	8	8	0
	D5732-1	2	0	0
	D5733-041	2	0	0
	MS21043-4	16	1,150	0
	MS21083C4	8	68	0
	NAS1149D0463J	8	4,298	0
	NAS1802-4-26	8	0	0
	<i>D5718-1</i>	<i>4</i>		

Part Specifications

Specifications could not be found.

Plex 7/18/19 7:18 AM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		Date: _____ Sequence #: _____ QTY Affected: _____		MRB (QS1042) ☐ ☐ ☐ ☐	
Description Work Order Deviation		Disposition		Completed By					
Root Cause		Fault Category		Lead hand / Supervisor					
Operator ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐		Contamination ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐		QC / QA Coordinator					
Pressure/Forced ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐		Power Loss/Surge ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐		Positioned Wrong ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐					
Other/Details: _____		Other/Details: _____		Other/Details: _____					

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1028-011 <i>Bearpaw Installation</i>	23.2 lb 10.5 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	207.0 in 5.26 m	4802 in-lb 55.2 m-kg
D117-1028-013 <i>Bearpaw Installation with Wearplates</i>	29.6 lb 13.5 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	205.9 in 5.21 m	6095 in-lb 70.3 m-kg
D117-1028-041 <i>Wearplate Kit</i>	6.4 lb 2.9 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	202.2 in 5.14 m	1294 in-lb 14.9 m-kg

5.0 PARTS LIST

QTY -011	QTY -013	QTY -041	Part Number	Description
X			D117-1028-011	BEARPAW INSTALLATION
	X		D117-1028-013	BEARPAW INSTALLATION WITH WEARPLATES
		X	D117-1028-041	WEARPLATE KIT
24	24	24	D2529	WASHER
4	4		D4012-3	CUSHION
2	2		D5732-1	BEARPAW (REPLACES D5700-1)
	2	2	D5733-041	BEARPAW WEARPLATE (REPLACES D5701-041)
4	4		D5718-1	CLAMP
4	4		D5718-3	CLAMP
8	8		D5719-1	RADIUS BLOCK
	16	16	AN4C5A	BOLT
8	24	24	MS21043-4	NUT
8	8	8	MS21083C4	NUT
8	8	8	NAS1149D0463J	WASHER
8	8	8	NAS1802-4-24	SCREW